

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029529**Date Inspected:** 27-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various Complete Joint Penetration (CJP) groove welds of the East and West Orthotropic Box Girders (OBG's).

The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

At the start of the shift this QAI observed the following:

This QAI witnessed the Bikepath lifting lug removal area Magnetic Particle/MT testing by the Quality Control(QC)Inspector Fred Michels at the following locations: PP78.5 (South), PP79.5 (North & South), PP80.5 (South) and PP81.5 (North & South). This QAI also performed the MT verification and inspections of Bikepath lifting lug removal areas at the following locations: PP79.5 (North & South) and PP80.5 (South). See the attached TL-6028 MT report for details. The work performed and the QC inspection and testing were observed and verified by this QAI appeared to be in compliance with the contract documents.

This QAI witnessed the Magnetic Particle Testing (MPT) and inspection of the lifting lug 'pyramid profile' removal areas of the longitudinal shear plate at L14W-W4-PP124.5 (North) by Quality Control(QC)Inspector Salvador Merino. This QAI also performed the MT verification inspection of the lifting lug 'pyramid profile' removal areas of this longitudinal stiffener at L14W-W4-PP124.5 (North). See the attached TL-6028 MT reports for details. There were no indications noted at this time.

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This QAI witnessed the Magnetic Particle Testing (MPT) and inspection of lifting lug 'pyramid profile' removal areas of the longitudinal shear plate at L14W-W4-PP122.65 (North) by AB/F Quality Control (QC) inspector Salvador Merino. This QAI also performed the MT verification inspection of the lifting lug 'pyramid profile' removal areas of this longitudinal stiffener at L14W-W4-PP122.65(North). See the attached TL-6028 MT reports for details. There were no indications noted at this time.

This QAI witnessed the Magnetic Particle Testing (MT) and inspections of the lifting lug 'pyramid profile' removal areas of the longitudinal shear plate at L14W-W4-PP121.65 (North) by AB/F Quality Control (QC) inspector Salvador Merino. This QAI also performed MT verification inspection of lifting lug 'pyramid profile' removal areas of this longitudinal stiffener at location L14W-W4-PP121.65(North). See the attached TL-6028 MT reports for details. There were no indications noted at this time.

This QAI performed the Ultrasonic Testing/UT verification inspections of lifting rod closure plate welds at locations EB-SLLH-14, EB-SLLH-15, EB-SLLH-16, and EB-SLLH-11. There were indications noted for both location EB-SLLH-16 and EB-SLLH-11. See the attached TL-6027 UT report for details.

This QAI witnessed the Magnetic Particle Testing (MPT) inspections of the lifting rod closure plate welds at locations EB-SLLH-16, and EB-SLLH-15 by AB/F Quality Control (QC) Inspector William Sherwood. This QAI also performed the MT verification inspection of these locations EB-SLLH-16, and EB-SLLH-15. See the attached TL-6028 MT report for details. There were no indications noted at this time.

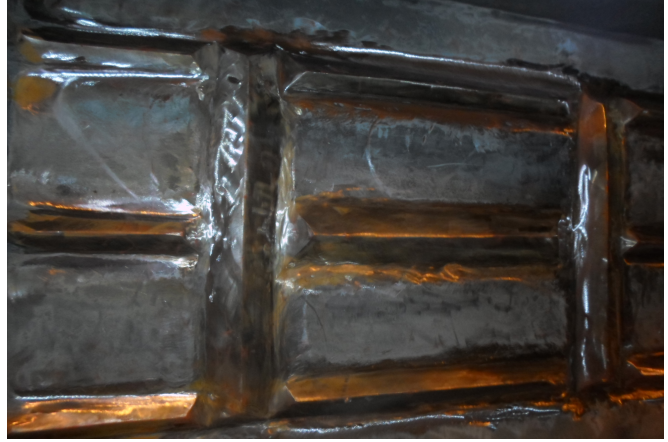
This QAI witnessed the Magnetic Particle Testing (MT) and inspection of the Eastbound Temporary support tower attachments to the bottom of the Floor deck at the North & West corner lugs (4 ea.) by AB/F Quality Control (QC) Inspector William Sherwood. This QAI also performed the MT verification testing of these Eastbound Temporary support tower attachments to the bottom of the Floor deck at the North & West corner lugs (4 ea.). See the attached TL-6028 MT report for details. There were no indications noted at this time. The removal areas and QC inspection were observed and verified by this QAI and appeared to be in compliance with the contract documents.

Unless otherwise noted, all the work observed on this date appeared to generally comply with the applicable contract documents.

The digital photographs on page three (3) of this report illustrates some of the work activities observed on this date:

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Summary of Conversations:

No significant conversations took place.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer